Work Orde August-28-13 12	r ID 106069 :40:05 PM	646	3910	*106	3069*							Page 1	_
Revision ID:	546.3910 SHIM	B 1 0	3069	Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*	Ξ.
Required Date: 8	8/28/13 Start Qty: Req'd Qty		*20* *20*		Cust Item II Customer:	D:							
Reference: Approvals:	Process Plan: _ <u></u> <u> </u>		Date: <u>13-08-79</u>	Tooling: SPC (Y/N):		ite:		1	Run	Start Stop		R1* R2*	
Sequence ID/ Work Center ID	Operation Description	1		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	•	Reject Number	Insp. Stamp	_
Draw Nbr 646.3900	Revision Nbr						, seemed to					* :	
110 *110* Waterjet		Iemo		0.00				20		υ		<u>Ac</u> 13:11.0	·2
FLOW CNC Waterje	D Pi	Cut as per Dowg Rev:	/C			·							
120 *120*	QC2- Inspect	parts off mac	hine FAI/FAIB	0.00				20		<i>c</i>)		Δ.	
QC Quality Control	N	femo		0.00				<u>~ ~ U</u>				13.11-6	ာ ခ

		•	•	-	
DQA:	Date:		•		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	2:
Work Order	·:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	o				Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	l .	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	g Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training											
Unapproved		<u> </u>				AULT CAT	FCORY				
Landin	a Coor				General	AULI CAI	EGONT				
Candin	Bending Centre No Cracks Crushed/		ntric to	o/s	Bend BOM/Route Broken/Damaged Burrs	—		/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Cuffs Heat Trea	-			Countersink	\vdash	tenance	Volicieal	Part Moved Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	Surge	Other
	Ripples in	n Bend		L	Drill Holes	Offset					
	Torque W	Vaves in I	Extrusio	n L	Drawing	Out of	^f Calibration				
	Turning S	equence			Finish	Out of	Sequence				
	Wave/Tw	vist in Tul	эе		Folio	Outsid	de Dimensions			· · · · · · · · · · · · · · · · · · ·	

Work Order ID August-28-13 12:40:05 F			*106	069 *						Page 2
Item ID: 646.3910 Revision ID: Item Name: SHIM Start Date: 8/28/13	Start Qty: 20.00	*20*	Accept	*N900		100)* s	etup Star Stop	ı Vı	S1* S2*
Required Date: 8/28/13 Reference:	Req'd Qty: 20.00	*20*		Customer:						
Approvals: Process	Plan:	Date:	Tooling:	Da	ıte:		F	tun Star	17	R1*
QC:		Date:	SPC (Y/N):	Da	ite:			Stop	*N	R2*
Sequence ID/ Work Center ID 130 *130* QG Quality Control	Operation Description QC8- Inspect parts - second	i check	Set Up/ Run Hours 0.00 DAS 27 9-89 0.00 B	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Outsource3 Outsource process - Cad plate	Outsource process-Cadplat Memo Issue P/O:		0.00	·			_Ca	(<u>13 11</u>	1/06	(20)_
150 Packaging Packaging	Receive & Inspect for Dam Memo	age & Mat'l Certs	0.00				<u>20x</u>	[i	15	-12-4

DAS 26 9-89

											DQA:	Date:	ີ
NCR: Y	es /	No				WORK ORDER NON-	COI	NFORN	MANCE / UPI	DATE	QA Closed:	 Date:	:
Work Orde						DISPOSITION				AGAINST DE		/PROCESS	
Part N	lo					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		T I			Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause	D	ate	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							FAUI	LT CATE	GORY				
Landi	n g Gea r Ber	nding				General Bend		Grain			Ovalized		Pressure/Forced
	Cer Cra		t Concer	ntric to ()/S	BOM/Route Broken/Damaged		Hardwa Inspecti	re on Incomplete		Over/Under Part Incorre	_	Temperature/Cure Weld
	Cru Cuf		Crimped			Burrs Contamination		Instruct Mainte	ions Incomplete/Unance	Jnclear	Part Lost/Mi Part Moved	issing	Wrong Stock Pulled
		at Trea pectior	t n Strip in	Tube		Countersink Cut Too Short		Mislabe Misread			Positioned V Power Loss/	· · · · · · · · · · · · · · · · · · ·	Other
	_	ples in			-	Drill Holes		Offset			·	<u> </u>	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 1		*106	3069*		Page 3
Item ID: 646.3910 Revision ID: Item Name: SHIM Start Date: 8/28/13 Required Date: 8/28/13	Start Qty: 20.00 Req'd Qty: 20.00	*20*	*N90004010 Cust Item ID: Customer:)∩* Setup Star Stop	14.71
Reference: Approvals: Process	Plan: Date:	Tooling:	Date:	Run Star Stop	"NR I"
Sequence ID/ Work Center ID 160 *160* QC Quality Control	Operation Description QC5- Inspect part completeness to s Memo	Set Up/ Run Hours tep on W/O 0.00 DAS 27 27 3-89 0.00	Tool ID Tool # Plan Cod		Reject Insp. Number Stamp
170 *170* Packaging Packaging	Identify as per dwg & Stock Location Memo ***IDENTIFY AS PER REV***	on: <u>51535</u> 0.00 0.00 APICAL MPP-120 BY STAMPING T	THE P# AND		_13-12-5
180 *180* QC Quality Control	QC21- Final Inspection - Work Ord Memo	er Release 0.00 0.00		13/1	2/9

M3-12-4

										DQA:	Date:	<i>G</i>
NCR: Y	es / No				WORK ORDER NON-O	100	VFORM	MANCE / UPI	DATE	QA Closed:	Date:	
<u></u>					DISPOSITION				AGAINST DE			
Work Orde	r:					.		F		· · · · · · · · · · · · · · · · · · ·		, –
					Rework		i .	Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo				Scrap			Machining	Small Fab	4	d. Eng. Coor.	Quality
N/CD A	1-				Use-as-is	4		noforming Large Fab	Finishing	Rec/Stor	re/Packaging	Other
NCR N	10				Work Order Update	J		Large Fab	Composite	İ	Supplier	
Root				Descri	iption of work order update	T 1	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other						1			•	1		·
Process												
Supplier					•							
Training		1										
Unapproved						$oldsymbol{ol}}}}}}}}}}}}}}}}}$				<u> </u>		
					F	AUI	LT CATE	GORY				
Landi	ng Gear				General	_	7			7		٦ .
	Bendin	_		L	Bend	_	Grain			Ovalized	<u> </u>	Pressure/Forced
ļ ·		Not Conce	ntric to	O/S	BOM/Route	_	Hardwa		<u> </u>	Over/Under		Temperature/Cure
,	Cracks			<u> </u>	Broken/Damaged	L		ion Incomplete		Part Incorre		Weld
		d/Crimped			Burrs	\vdash	-1	tions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	\perp	Mainte		<u> </u>	Part Moved		
	Heat T	reat			Countersink		Mislabe	eled	i	Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

August-28-13 12:40:04 PM

Page 1

Work Order ID:

106069

Parent Item:

646.3910

Parent Item Name:

SHIM

Start Date: 8/28/13

Required Date: 8/28/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A 12.12.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.020 C1095 Blue Tempered Spr	ing Steel Sheet .020	Purchased	No			110	sf	28.4000	0.03	0.631578	Au	13 1	11.02

Location	Loc Qty	Loc Code
MAT022	28.4	
123537	5.4	
m126423	23	

126423 -- ,632

											DQA:	Da	te:	ن
NCR:	/es	/ No				WORK ORDER NON-	201	NFORM	AANCE / UPE	DATE	QA Closed:	Da	te:	
		,									<u> </u>			
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
	- • •	<u> </u>				Rework	1	·	Skid-tube	Crosstube	1	Water Jet		Engineering
Part I	۷o.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	•					Use-as-is	1	Therm	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR I	No.					Work Order Update	1		Large Fab	Composite		Supplier		
Root						ption of work order update		Initial	Act		Sign &			
Cause		Date	Step	Qty	<u></u>	or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verificatio	n	QC Inspector
Doc/Data	Щ					•	1							
Equip/Tooling	Ш													
Operator	Ш]					!			İ			
Material							Ì		•					
Setup									i					
Other .														
Process	Ŀ													
Supplier						. *					Í			
Training	┕											1		
Unapproved							<u> </u>				<u> </u>			
					· · · · · · · · · · · · · · · · · · ·		AUL	LT CATE	GORY		 			
Land	ng (_	General	_	. .		F	1			1
	<u> </u>	Bending			<u> </u>	Bend		Grain		<u> </u>	Ovalized		_	Pressure/Forced
	_	Centre N	ot Conce	ntric to (o/s	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under		<u> </u>	Temperature/Cure
		Cracks			L	Broken/Damaged		-i '	on incomplete	·	Part Incorre		Ľ	Weld
		Crushed/	Crimped		<u> </u>	Burrs	L_	4	ions Incomplete/U	Jnclear	Part Lost/M	•		Wrong Stock Pulled
	<u></u>	Cuffs				Contamination		Mainte			Part Moved			
		Heat Trea	at			Countersink		Mislabe	eled .		Positioned \	V rong		-
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss,	'Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

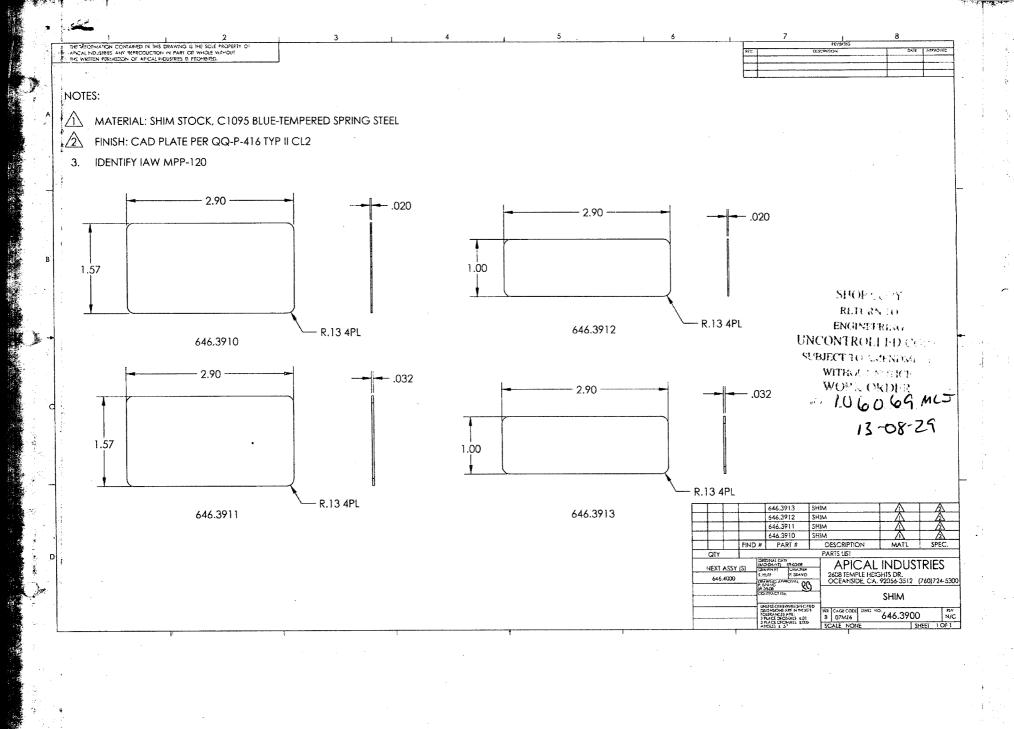
DART AEROSPACE LTD	Work Order:	106069
Description: Shim	Part Number:	646.3910
Inspection Dwg: 646.3900 Rev: N/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		1111011	AITHOLL III				·
Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.57	03	+/-0.005	1,58"	~		ν	UKM-01
	03	<u> </u>	2.91"	_		V	
	COL		.020"	_		V	
1000	CIL	J	·······································				
				,			
	$\neg \uparrow$				· · · · · · · · · · · · · · · · · · ·		
<u> </u>							
				<u> </u>			
	-						
					 		
					 		
					 		
					 		
			<u> </u>	DAS _	<u> </u>		

DAS				
Measured by:	Audited by:	27	Preliminary Approval:	
Date: 13.11.02	Date:	12/11/14	Date:	
13/1/00				

Rev	Date	Change	Revised by	
A	12.11.30	New Issue	KJ 🥎	ALL
	12.11.00		·	, .



CERTIFICATE OF CONFORMANCE

CADORATH PLATING CO. LTD. 2150 LOGAN AVENUE WINNIPEG, MANITOBA R2J-0J1

DATE:

Dec-02-2013

CONSIGNED TO: Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

W/O #:

130248

INVOICE #:

68742

CONTRACT OR

PURCHASE ORDER #

PO21961

DESCRIPTION: SHIM

QTY

20

P/N# 646.3910

S/N # 106069

CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 2. BAKE HEAT CHART # 13-1051

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector: